

Date: Thursday, 08/05/2008 12:00:09 PM  
 User: Julie Lecocq

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FLOAT WEB
Job Number	: 39127		
Estimate Number	: 10791		
P.O. Number	:	Part Number	: D3282041
This Issue	: 08/05/2008 S.O. No. :	Drawing Number	: D3282 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / /	Drawing Revision	: C
Previous Run	: 37052	Material	:
Written By	:	Due Date	: 30/05/2008
Checked & Approved By	: <u>JLD 08.5.08</u>	Qty:	4 Um: Each
Comment	: Est Rev:B 05.09.23 Procedure change KJ/JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2792130	EXTRUSION
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2792-130	Extrusion	<u>33518</u>

Identify as D3282-1

BT 08-05-12

2.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Cut to length as per Dwg D3282.

2- inspect for surface damage as per QSI0018

BT 08-05-12

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per Folio FA579 &amp; Dwg D3282

2-Deburr

M.A 08/07/19

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

M.A 08/07/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 08/05/2008 12:00:09 PM  
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT WEB

Job Number: 39127

Part Number: D3282041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

800/07/21 (84)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SL 8-7-22

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

DP 8-2-22

8.0

D32831

Doubler



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D3283-1

Doubler

39163

SL 8-7-22

822

9.0

MS20470AD47

Rivet, Universal Head



Comment: Qty.: 57.0000 Each(s)/Unit Total : 228.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

57 MS20470AD4-7

Rivet

106574

SL 8-7-22

229

10.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install doublers as per Dwg D3282. Apply LPS-3 between doublers and web

ARN/ALPS-3 103674

SL 8-7-22

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

800/07/22 (84)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 08/05/2008 12:00:09 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT WEB

Job Number: 39127

Part Number: D3282041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: LG

GL 8-7-22

(4)

13.0

QC21

FINAL INSPECTION/W/O RELEASE



08/07/23

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 08-07-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 39127
<b>Description:</b> Float Web		<b>Part Number:</b> D3282-041
<b>Inspection Dwg:</b> D3282	<b>Rev:</b> C	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
126.6	+/-0.100	126.6	✓		Tape	
1.500	+/-0.010	1.502	✓			
3.000	+/-0.010	3.000	✓			
6.000	+/-0.010	5.999	✓			
1.250	+/-0.010	1.251	✓			
30.000	+/-0.010	30.000	✓		Tape	
1.500	+/-0.010	3.000	✓			
72.01	+/-0.030	72.01	✓		Tape	
61.75	+/-0.030	61.75	✓		Tape	
57.50	+/-0.030	57.50	✓		Tape	
49.19	+/-0.030	49.19	✓		Tape	
43.94	+/-0.030	43.94	✓		Tape	
39.69	+/-0.030	39.69	✓		Tape	
26.68	+/-0.030	26.68	✓		Tape	
0.55	+/-0.030	0.5475	✓			
1.970	+/-0.010	1.964	✓			
2.38	+/-0.030	2.378	✓			
0.05	+/-0.030	0.053	✓			

<b>Measured by:</b> M.A	<b>Audited by:</b> S	<b>Prototype Approval:</b> N/A
<b>Date:</b> 08/07/19	<b>Date:</b> 08/07/19	<b>Date:</b> N/A

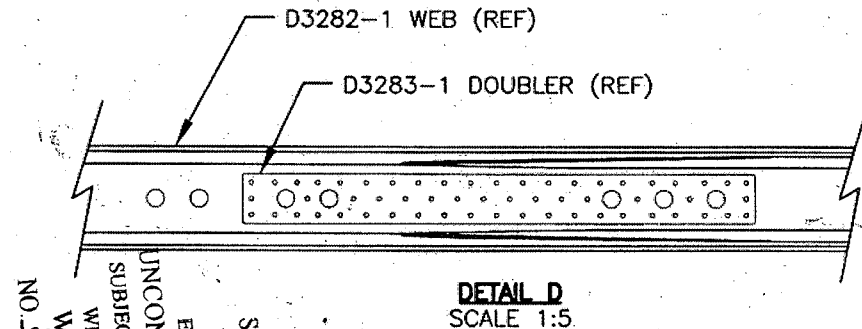
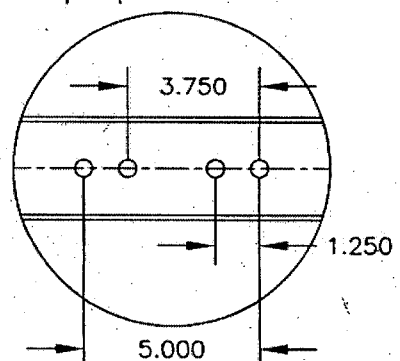
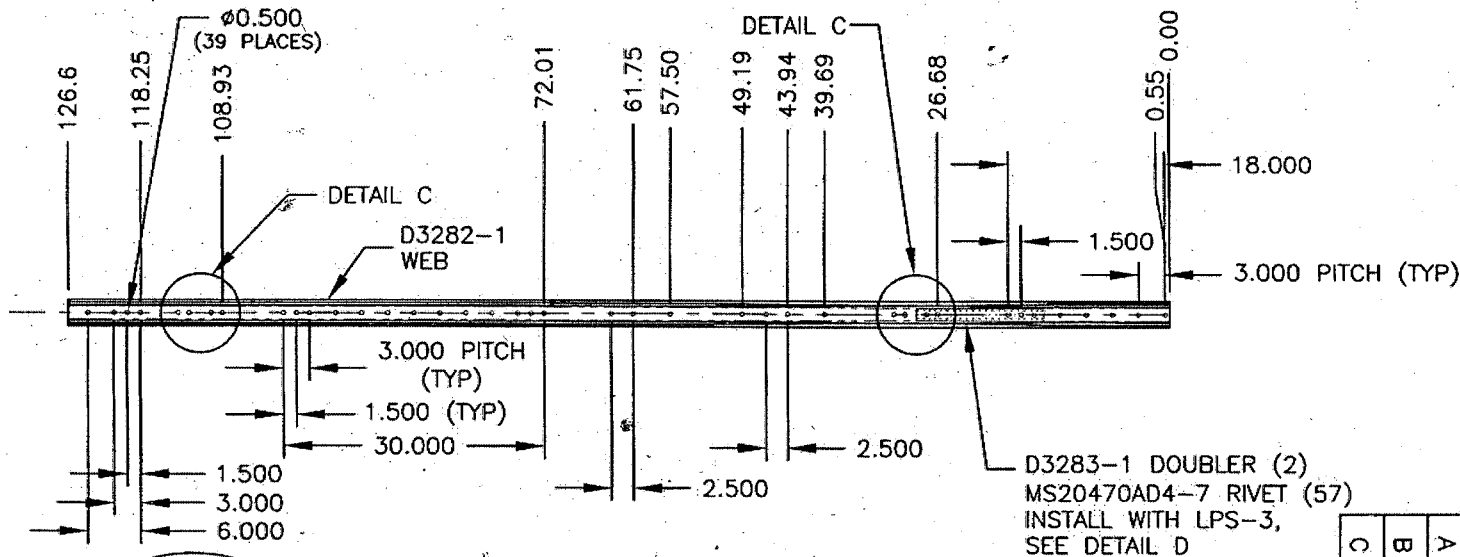
Rev	Date	Change	Revised by	Approved
A	07.04.02	New Issue	KJ/JLM	

12/12/88





DESIGN	CP	DRAWN BY	CP	DART AEROSPACE USA, INC.
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	PORT HADLOCK, WA
DATE	05.08.09	DRAWING NO.	D3282	REV. C
		TITLE	SCALE	
		05.08.09	1:20	
A	04.05.05	NEW ISSUE		
B	05.03.16	MOVE HOLES, ADD D3390-1 DOUBLERS		
C	05.08.09	REMOVE D3390-1, NOW MACHINED		



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WITHOUT NOTICE  
WORK ORDER  
NO. 3107

RELEASED  
05.09.12

**D3282-041 FLOAT WEB**

- 1) MAKE FROM D2792-130 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) APPLY A LAYER OF LPS LABORATORIES' LPS-3 BETWEEN D3283-1 DOUBLERS AND D3282-1 WEB. INSTALL RIVETS COATED WITH LPS-3
- 6) SEE PAGE 2 FOR MACHINING DETAILS



DESIGN	CP	DRAWN BY	CP	DART AEROSPACE USA, INC.
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	PORT HADLOCK, WA
DATE	05.08.09	TITLE	D3282	REV. C
				SHEET 2 OF 2
				SCALE
				1:20

## SECTION B-B

D3283-1  
DOUBLER  
(REF)

1.970  
(REF)

D2792-130  
EXTRUSION  
(REF)

## SECTION A-A

R0.250  
(TYP)

0.05  
(TYP)

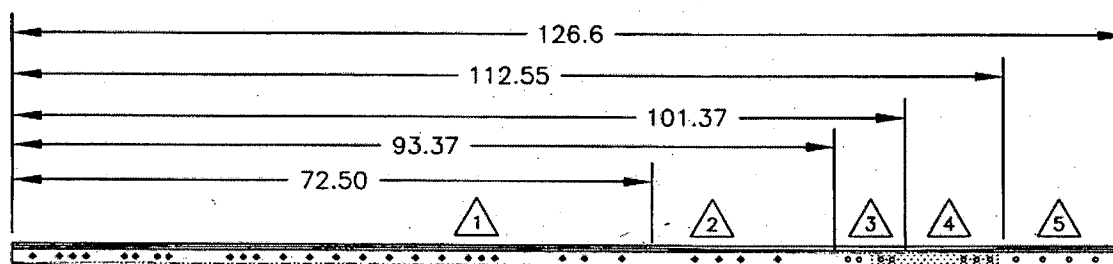
2.38

D2792-130  
EXTRUSION  
(REF)

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WORK ORDER  
NO. 39127

### D3282-1 MACHINING NOTES

- 1 UNIFORM SECTION A-A
- 2 UNIFORM TAPER FROM SECTION A-A TO SECTION B-B
- 3 UNIFORM SECTION B-B
- 4 UNIFORM TAPER FROM SECTION B-B TO SECTION A-A
- 5 DRILL #30 (Ø0.128 REF) HOLES (57 PLACES) TO LINE UP WITH D3283-1, SEE DETAIL D FOR REFERENCE
- 6 UNIFORM SECTION A-A
- 7 R1.00 BETWEEN SECTIONS



RELEASED  
05.09.12

